

slp 27/12

Work Order ID 77707

77707

Page 1

December-19-11 8:20:14 AM

Item ID: D3017-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Back Frame Assembly
 Start Date: 19/12/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 28/12/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3017	Rev B

100 . Weld per dwg A/R 4130 rod Batch: M118875 0.00
 Large Fab
 100
 Large Fab Memo 0.00
 Large Fab 1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017
 2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)
 3-Drill holes in D3017-5 Using DT8622
 4-Deburr
 5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
 6-Drill holes in back frame using DT8621

12 11/12/20 XI

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110
 QC Memo 0.00
 Quality Control

1 0 BE11-12-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 9:10 OVEN TEMPERATURE: 320°C FINISH TIME: 9:40	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

Handwritten signatures and dates:
11/12/2011
11/12/2011
11/12/2011

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

PP 77706

12/21/11

12/21/11

MF 11-12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-19-11 8:20:18 AM

Page 1

Work Order ID: 77707

77707

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 19/12/2011

Required Date: 28/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.083

Purchased

No

100

f

45.6570

2.458

2.587368

M4130NT0 750W 083

4130 RD Tube .750 x.083W

**

EL 11-12-19

Location

Loc Qty

Loc Code

MAT033

45.657

117579

21.74

117973

23.917

2.58

M4130NT0.750W.049

Purchased

No

100

f

51.2700

11.125

11.71053

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

EL 11-12-19

Location

Loc Qty

Loc Code

MAT033

51.27

118772

51.27

22.5

D3017-11

Manufactured

No

100

Each

60.0000

2

2

D3017-11

cap

**

EL 11-12-20

Location

Loc Qty

Loc Code

WA021

60

76851

60

2

D3017-7

Manufactured

No

100

Each

16.0000

3

3

D3017-7

Lug

**

EL 11-12-19

Location

Loc Qty

Loc Code

WA021

16

69166

1

70871

7

70905

8

3

Back panel

D3023-1

B 76360 K1

EL 11-12-20

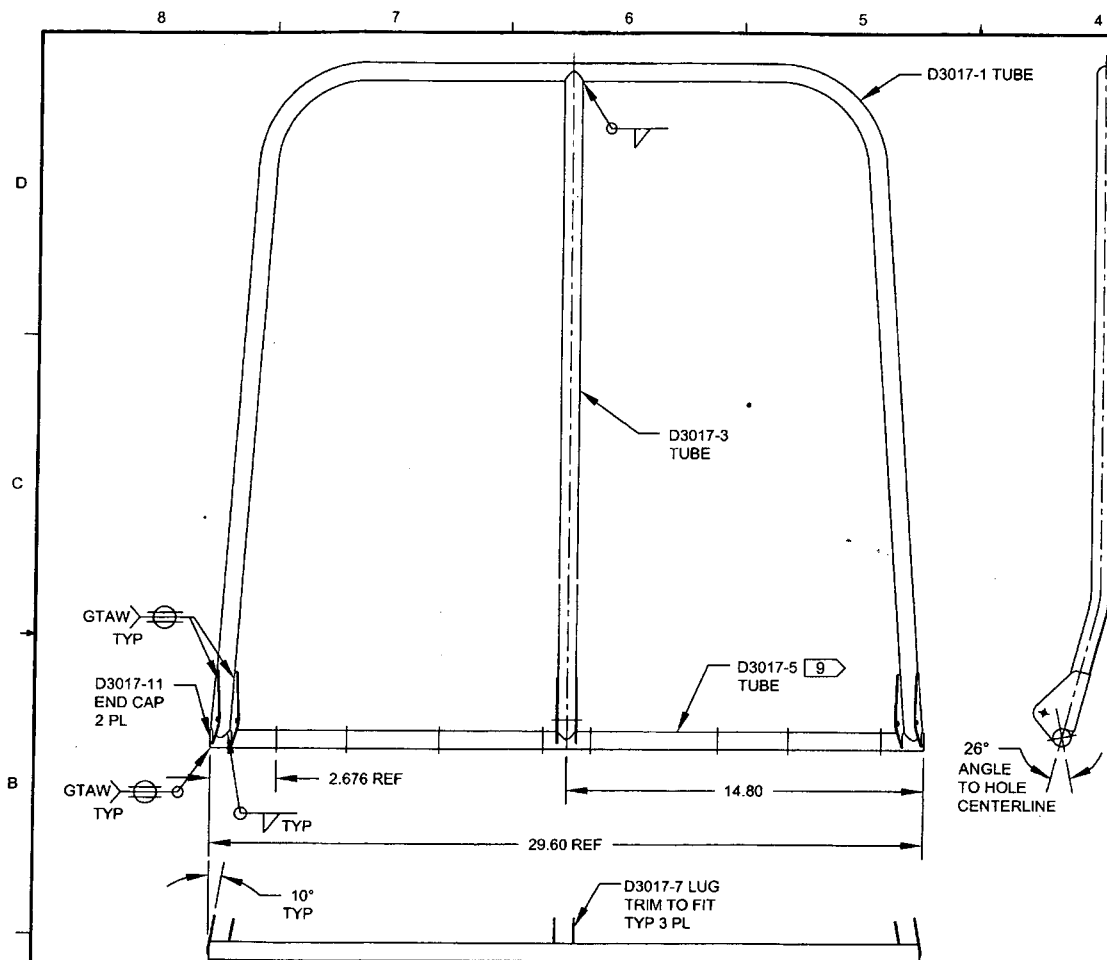
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

SHOP COPY
RETURN TO
ISSUING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

7770 F.M.C. 5
11/12/19

RELEASED
2010-02-02
WJP

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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Dart Aerospace Ltd

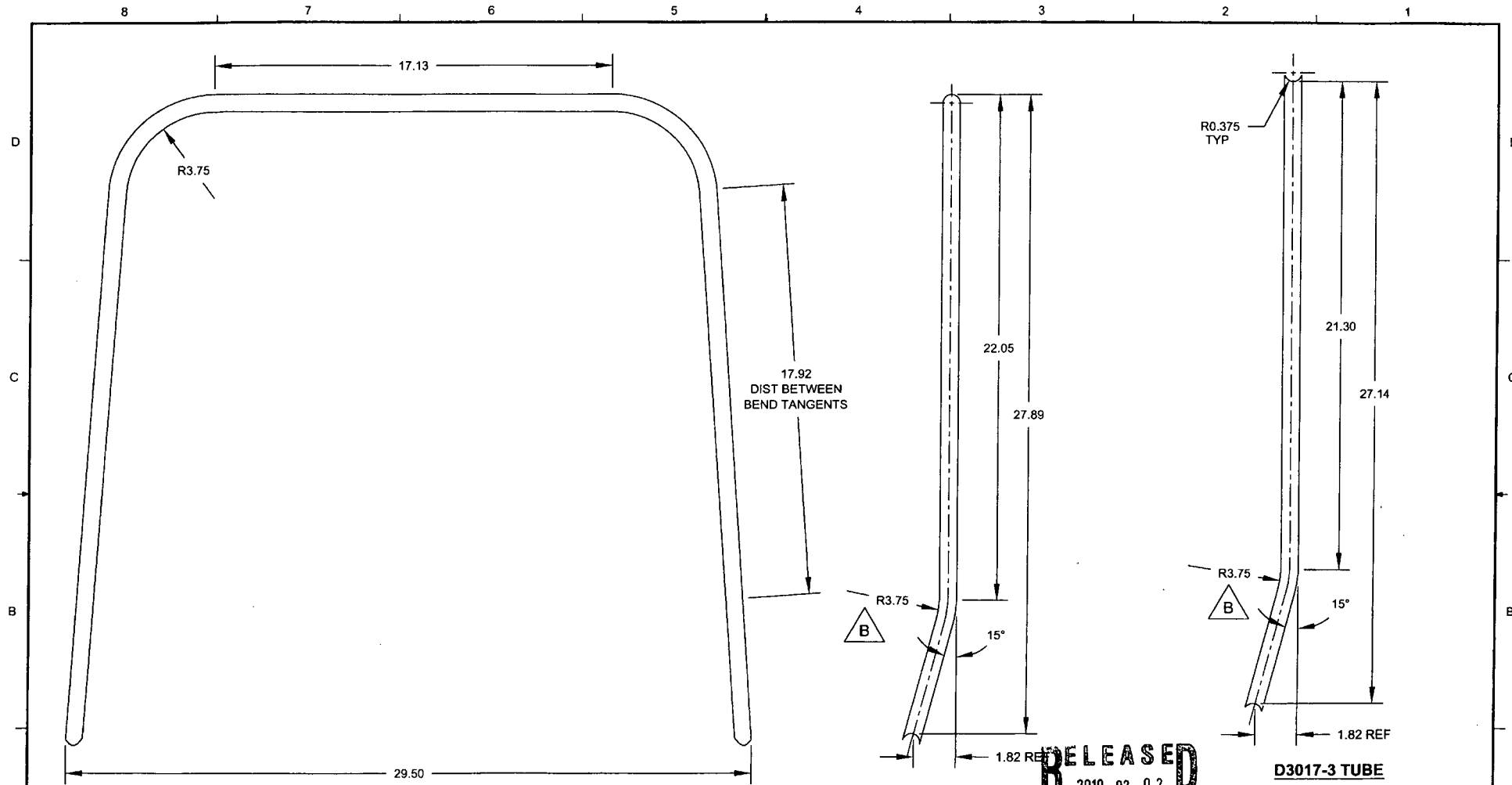
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77707



D3017-1 TUBE

D3017-3 TUBE

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

RELEASED
2010-02-02
MWP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 2 OF 4
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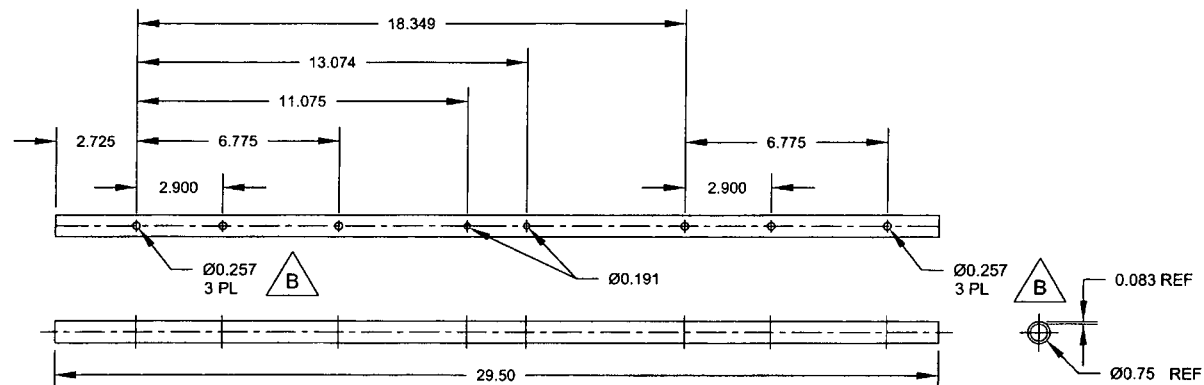
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77707



D3017-5 TUBE

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, 0.75 DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs

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MFG. APPR.		D3017	SHEET 3 OF 4
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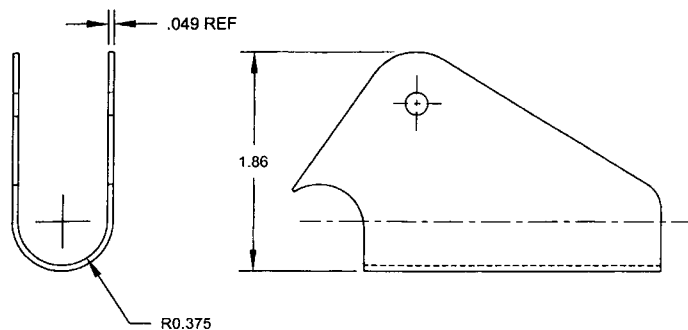
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D

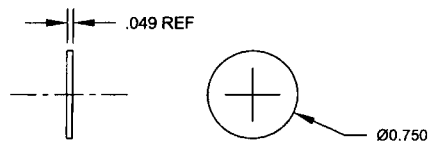
C

B

A



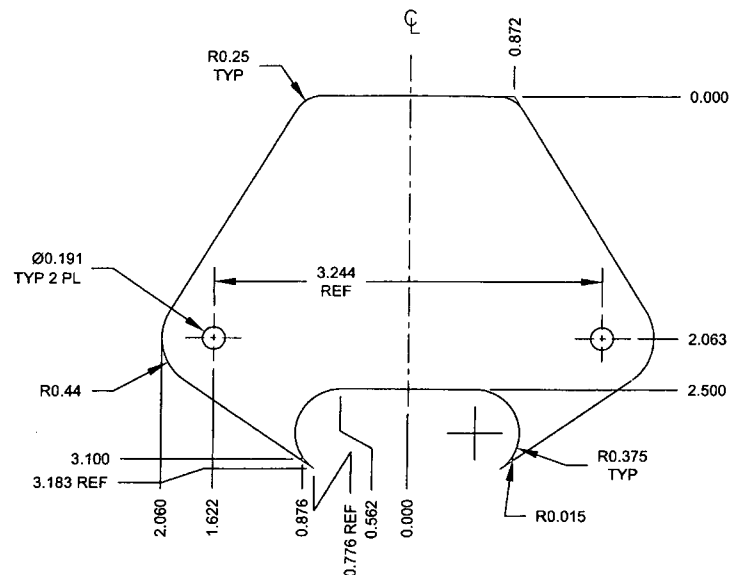
D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3017	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV 0

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

PURPOSE:

TO PROVIDE REWORK INSTRUCTIONS TO INSTALL DSI-9495-011 REINFORCED BACK FRAME KIT. THESE INSTRUCTIONS ARE APPLICABLE TO D350-689-011 AT CHANGE 002, D350-689-021 AT CHANGE 001, D350-689-041 AT CHANGE 001 AND D350-689-043 AT CHANGE 001 OR EARLIER CHANGE NUMBER.

CHANGE:

REPLACE EXISTING BACK ASSEMBLY WITH DSI 9495-011 REINFORCED BACK FRAME KIT.

PARTS LIST:

Qty -011	Part Number	Description
X	DSI-9495-011	REINFORCED BACK FRAME KIT
1	D3017-041	BACK FRAME ASSEMBLY
1	D3023-1	BACK PANEL
2	NAS1149D0332J	WASHER (OR AN960JD10L)
6	NAS1149D0432J	WASHER (OR AN960JD416)
40	MS20600AD4W2	RIVET
6	MS20600AD4W3	RIVET (REF DSI 9349)
2	MS27039-1-17	SCREW
6	MS27039-4-21	SCREW
2	MS21042L3	NUT (OR MS21042-3)
6	MS21042L4	NUT (OR MS21042-4)

INSTRUCTIONS:

1. REMOVE LAP BELT AND HARNESS (IF APPLICABLE).
2. REMOVE EXISTING D3017-041 BACK FRAME ASSY.
3. INSTALL PROVIDED D3017-041 BACK FRAME ASSEMBLY WITH ATTACHED PARTS USING ORIGINAL HARDWARE ON EITHER SIDE OF THE CENTER TUBE.
4. TRANSFER Ø0.257" HOLES (SEE SHEET 2 OF THIS SERVICE INSTRUCTION FOR REFERENCE, 6 PLACES) USING THE BACK FRAME ASSEMBLY AS A TEMPLATE TO OPEN UP THE HOLES IN THE SEAT FRAME ASSEMBLY.
5. REMOVE NEW BACK FRAME ASSEMBLY.
6. REMOVE BURRS AND SHARP EDGES. TOUCH UP PER ICA-D350-689 CHAPTER 5.2 SECTION 8 AS REQUIRED.
7. REINSTALL PROVIDED BACK FRAME ASSEMBLY WITH ATTACHED BACK PANEL USING THE HARDWARE PROVIDED PER FIGURE 1 (SHEET 2).
8. REMOVE FROM OLD BACK ASSEMBLY:
D3031-1 LOOP AND HARDWARE (2 PLACES) AND TRANSFER TO NEW BACK ASSEMBLY.
D3024-1 SPACER AND HARDWARE (3 PLACES) AND TRANSFER TO NEW BACK ASSEMBLY.
9. INSTALL LAP BELT AND HARNESS (IF APPLICABLE).
10. THE PARTS LIST AND WEIGHT & BALANCE SHOULD BE UPDATED PER DSI 9498.

(INSPECT REMOVED HARDWARE FOR WEAR AND REPLACE AS REQUIRED)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD
D. SHEPHERD (DE # 02)

DATE: 10.01.13
CERT. NO.: SH02-33
ISSUE NO.: 1

A	NEW ISSUE.	JPH	10.01.13
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9495	SHEET 1 OF 2
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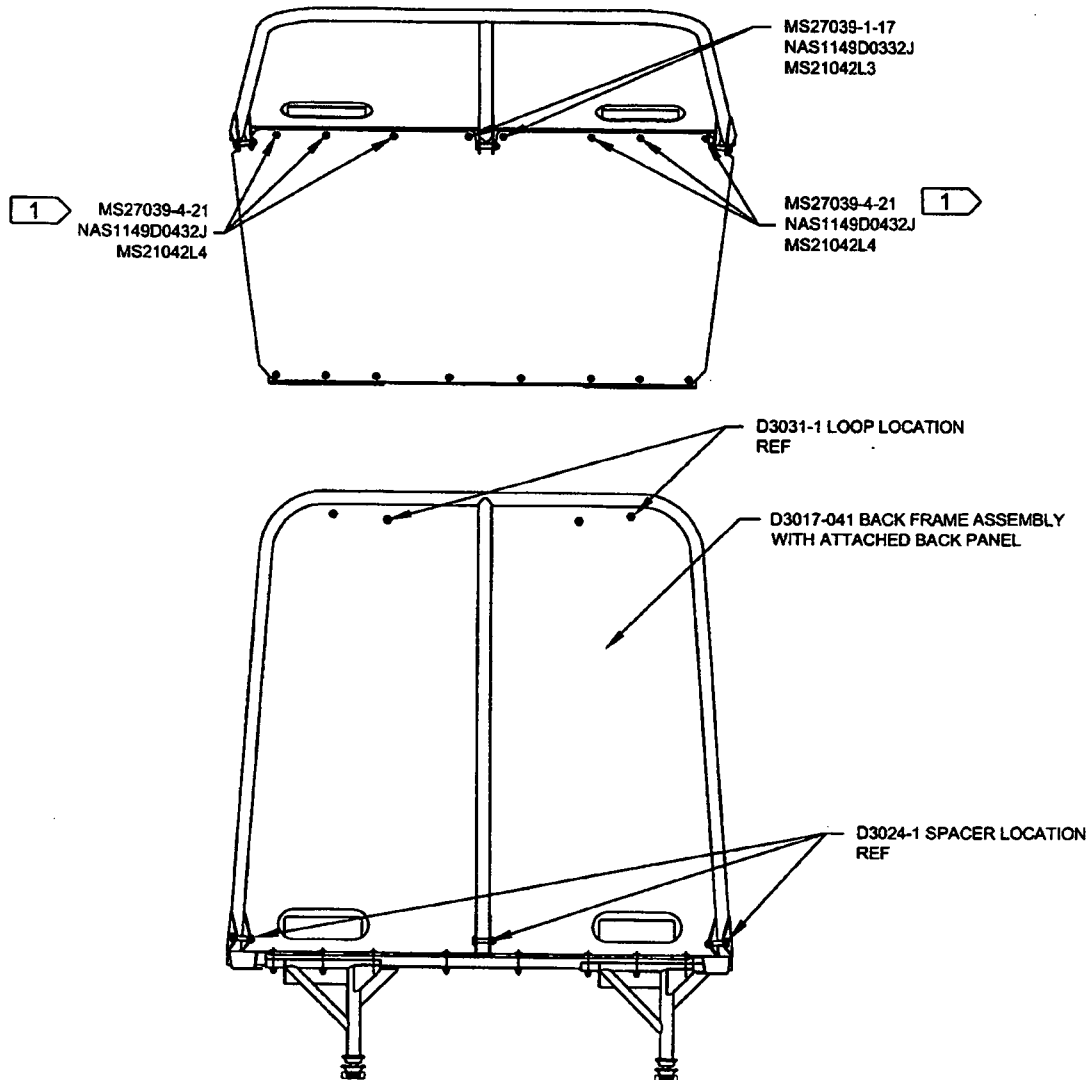


FIGURE 1
DUAL HIGH BACK SEAT ASSEMBLY WITH
DSI9495-011






1 OPEN EXISTING HOLES IN SEAT FRAME ASSEMBLY
 TO Ø0.257"

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-O-01

APPROVED

BY: *[Signature]*
 D. SHEPHERD (DE # 02)

DATE: 10.01.13
 CERT. NO.: SH02-33
 ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
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